



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4146-1

Job Sheet 189205



Part No: D4146-1

Job Qty: 20 pcs

Part Name: Fitting



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/21/19

Job Tracking No:

Due Date: 2/9/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 10-10-05 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	20 pcs	2/9/19	2/9/19	0.00	8.00	Doosan - 1		jk
120	QC 8	20 pcs	2/9/19	2/9/19	0.00	0.00	QC 8 - 12		FEB 19/02/19
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
130	Packaging 3-1 - Stock - B4B	20 pcs	2/9/19	2/9/19	0.00	0.00	Packaging 3 - 1 - B4B		FEB 13 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		



Container No: S152202



Part: D4146-1

Job No: 189205

Serial No/Batch: S152202

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K64 1K7

CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 02/09/19

57579				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
140 QC 21 - SA				20 pcs	
				2/9/19	
				0.00 0.00	
				QC 21 - SA - 21	
				QC 21 - SA - 70	

DAS FEB 14 2019

Part Op 100 - (Doosan Lathe)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

21
 0-00

Job BOM

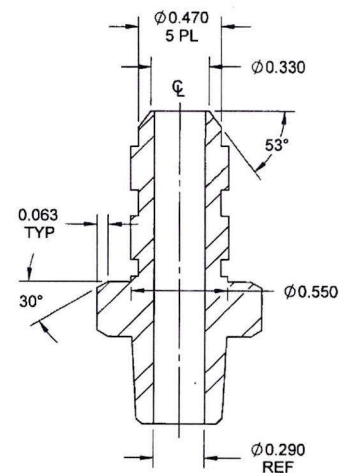
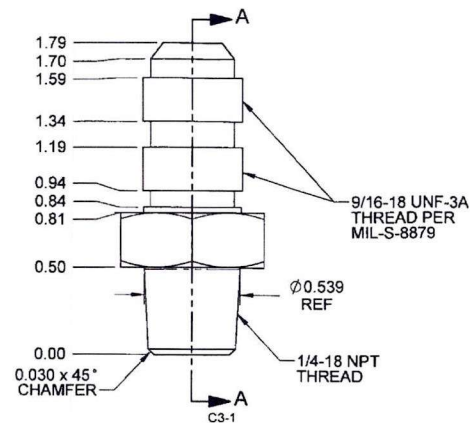
Part / Item	Component Name	Quantity	Operation	Container
M303R1.000	303 Round Bar 1.00	3.3320 ft (.1666 ea)	100-Doosan - 1	5150607

Job Allocations

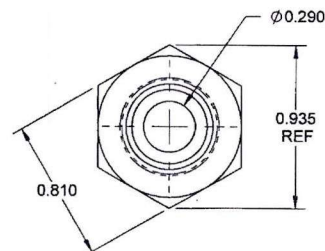
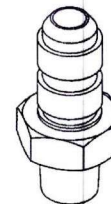
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R1.000	3	0	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fitting	0.290Inches + 0.006 - 0.001	0.296 0.289	Diameter	
2	Fitting	0.810Inches ± 0.010	0.820 0.800		
3	Fitting	0.550Inches ± 0.010	0.560 0.540	Diameter	
4	Fitting	0.470Inches ± 0.010	0.480 0.460	Diameter	
5	Fitting	0.330Inches ± 0.010	0.340 0.320	Diameter	
6	Fitting	0.063Inches ± 0.010	0.073 0.053		
7	Fitting	1.790Inches ± 0.030	1.820 1.760		
8	Fitting	1.700Inches ± 0.030	1.730 1.670		
9	Fitting	1.590Inches ± 0.030	1.620 1.560		
10	Fitting	1.190Inches ± 0.030	1.220 1.160		
11	Fitting	0.840Inches ± 0.030	0.870 0.810		
12	Fitting	0.810Inches ± 0.030	0.840 0.780		
13	Fitting	0.500Inches ± 0.030	0.530 0.470		
14	Fitting	0.539Inches ± 0.010	0.549 0.529	Diameter	

Plex 1/21/19 2:25 PM Dart.Macdonald.Dara



SECTION A-A C5-1



D4146-1 FITTING

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL HEX BAR OR
AISI 303 STAINLESS STEEL ROUND BAR
DART SPEC. M303H OR M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.11 lbs

RELEASED
2010-09-23

A		NEW ISSUE		RF	10.09.16
REV.		DESCRIPTION		BY	DATE
DESIGN		RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D4146 TITLE FITTING SCALE NTS		
DRAWN		RF			
CHECKED		RF			
MFG. APPR.		RF			
APPROVED		RF			
DE APPR.		RF			
DATE		10.09.16	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					